

Date: Tuesday, 15/07/2008 4:12:01 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
<b>Job Number</b> :	40516	<b>Part Number</b> :	D2573		
<b>Estimate Number</b> :	10533	<b>Drawing Number</b> :	D2573 REV E		
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A		
<b>This Issue</b> :	15/07/2008	<b>S.O. No.</b> :		<b>Drawing Revision</b> :	E
<b>Prsht Rev.</b> :	NC	<b>Type</b> :	MACHINED PARTS		
<b>First Issue</b> :	1/1	<b>Material</b> :			
<b>Previous Run</b> :	40198	<b>Due Date</b> :	08/08/2008	<b>Qty:</b>	10 Um: Each
<b>Written By</b> :					
<b>Checked &amp; Approved By</b> :	<u>JLD 08.7.16</u>				
<b>Comment</b> :	Est. I As Per RevE 06-01-27 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: B34875

mk 08/08/16

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 4056 Double check by: H.A

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

mk J.F. 08/08/20

(10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

mk J.F. 08/08/20

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mk J.F. 08/08/20

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:02 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 40516

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mf* 08/08/20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*m2/m* 08/08/20

(X10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9-20  
320 °F  
9-50

*m.f* 08/08/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*MS*



Comment: INSPECT POWDER COAT

08.08-21

(2X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SI443*

*C2* 08/08/21

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



*mf* 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 40516
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.502	.502	.504		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.500	.500		
J	1.174	1.184		1.179	1.181	1.179	1.179		
K	0.558	0.578		.566	.566	.569	.567		
L	1.174	1.184		1.179	1.181	1.179	1.179		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.123	4.125	4.125		
P	0.115	0.135		.126	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.125		
R	0.240	0.260		.249	.252	.252	.251		
S	0.115	0.135		.121	.120	.120	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.230	3.230	3.236		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.122	.123	.122	.121		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.766		
Z	0.352	0.372		.359	.365	.367	.363		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.631	.634	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.244	.245	.244		
AE	1.500	1.520		1.512	1.512	1.514	1.513		
AF	0.115	0.135		.127	.127	.127	.130		
AG	0.240	0.280		.268	.265	.262	.261		
AH	0.240	0.260		.249	.251	.250	.250		
AI	2.000	2.020		2.000	2.000	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/08/18

Audited by:	<i>[Signature]</i>
Date:	08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40514
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	0.439"	0.439"	0.439"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500	3.501"	3.501"	3.501"		
D	1.745	1.755		1.750	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000	8.004"	8.004"	8.004"		
F	0.490	0.510		.507	.504"	.507"	.509"		
G	0.257	0.262		.260	.260	.260	0.257"		
H	0.375	0.380		.378	.378	.378	0.377"		
I	0.490	0.510		.501	.501	.500	.501"		
J	1.174	1.184		1.180	1.179	1.179	1.179"		
K	0.558	0.578		.565	.566	.567	.571"		
L	1.174	1.184		1.180	1.179	1.179	1.179"		
M	1.365	1.375		1.368	1.370	1.370	1.370"		
N	2.495	2.505		2.499	2.499	2.500	2.500"		
O	4.119	4.129		4.125	4.126	4.125	4.125"		
P	0.115	0.135		.127	.127	.127	.126"		
Q	0.115	0.135		.135	.135	.135	.120"		
R	0.240	0.260		.251	.251	.252	.250"		
S	0.115	0.135		.115	.119	.120	.125"		
T	0.178	0.198		.188	.188	.188	.188"		
U	3.210	3.250		3.230	3.228	3.229	3.230"		
V	0.230	0.250		.240	.240	.240	.239"		
W	0.115	0.135		.123	.120	.121	.125"		
X	0.308	0.313		.310	.311"	.311"	.311"		
Y	0.760	0.765		.761	.760"	.760"	.761"		
Z	0.352	0.372		.365	.364"	.362"	.369"		
AA	0.470	0.530		.500	.500	.500	R.500"		
AB	0.615	0.635		.635	.635"	.634"	.634"		
AC	0.053	0.073		.063	.063	.063	.063"		
AD	0.240	0.260		.241	.242	.246	.250"		
AE	1.500	1.520		1.513	1.513	1.515	1.513"		
AF	0.115	0.135		.131	.125	.127	.135"		
AG	0.240	0.280		.265	.265	.265	.273"		
AH	0.240	0.260		.249	.248	.248	.251"		
AI	2.000	2.020		2.002	2.002	2.004	2.002"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		
Accept/Reject									

Measured by: JML / J.F.
Date: 08/08/18

Audited by: J.S.
Date: 08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40516
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3	4		
A	0.438	0.443		0.439"	0.439"				
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.005"	8.005"				
F	0.490	0.510		0.507"	0.508"				
G	0.257	0.262		0.258"	0.258"				
H	0.375	0.380		0.377"	0.377"				
I	0.490	0.510		0.502"	0.506"				
J	1.174	1.184		1.179"	1.179"				
K	0.558	0.578		0.567"	0.570"				
L	1.174	1.184		1.179"	1.179"				
M	1.365	1.375		1.370"	1.370"				
N	2.495	2.505		2.500"	2.500"				
O	4.119	4.129		4.125"	4.125"				
P	0.115	0.135		0.126"	0.124"				
Q	0.115	0.135		0.130"	0.130"				
R	0.240	0.260		0.251"	0.250"				
S	0.115	0.135		0.120"	0.124"				
T	0.178	0.198		0.188"	0.188"				
U	3.210	3.250		3.230"	3.230"				
V	0.230	0.250		0.239"	0.238"				
W	0.115	0.135		0.124"	0.125"				
X	0.308	0.313		0.312"	0.311"				
Y	0.760	0.765		0.761"	0.761"				
Z	0.352	0.372		0.370"	0.370"				
AA	0.470	0.530		0.500"	0.500"				
AB	0.615	0.635		0.635"	0.630"				
AC	0.053	0.073		0.063"	0.063"				
AD	0.240	0.260		0.250"	0.250"				
AE	1.500	1.520		1.513"	1.512"				
AF	0.115	0.135		0.135"	0.135"				
AG	0.240	0.280		0.273"	0.273"				
AH	0.240	0.260		0.251"	0.251"				
AI	2.000	2.020		2.003"	2.002"				
AJ	0.023	0.043		0.033"	0.033"				
Accept/Reject									

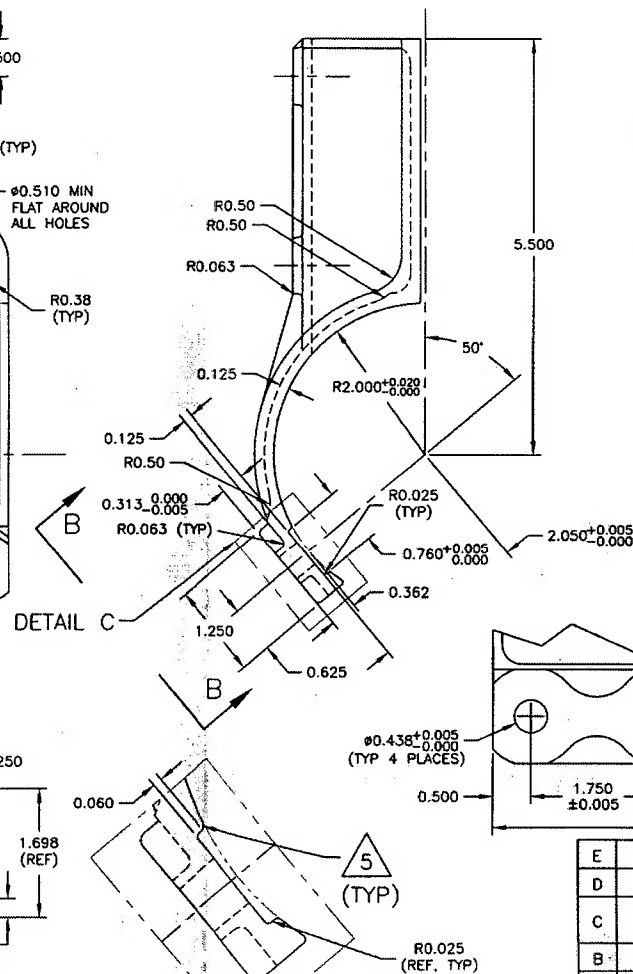
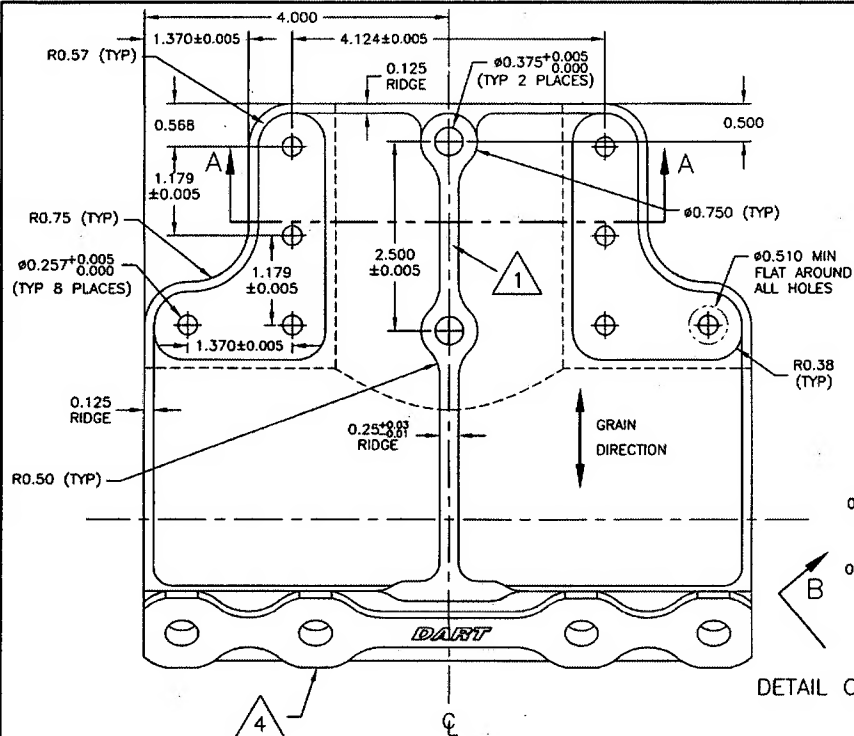
Measured by: J.F.
Date: 08/08/20

Audited by: [Signature]
Date: 08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

RELEASED

05.12.06

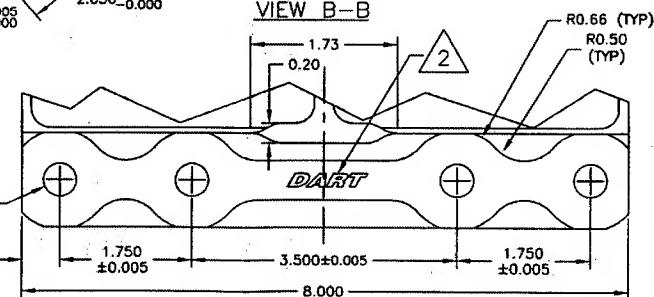
DETAIL C  
SCALE 4:3

## NOTES

MATERIAL: 7075-T7351 (00-A-250/12)  
(REF DART SPEC. 06102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
		SCALE	2:3		

NO. 40574  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY